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*Publication date:*  
2007

*Document Version*  
Publisher's PDF, also known as Version of record

[Link back to DTU Orbit](#)

*Citation (APA):*  
Due-Hansen, J., Rasmussen, S. B., Kustov, A., Siret, B., Tabaries, F., & Fehrmann, R. (2007). *Regeneration of Pt-catalysts deactivated in municipal waste flue gas with H<sub>2</sub>/N<sub>2</sub> and the effect of regeneration step on the SCR catalyst*. Poster session presented at 8th European Congress on Catalysis, Turku, Finland.

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# Regeneration of Pt-catalysts deactivated in municipal waste flue gas with H<sub>2</sub>/N<sub>2</sub> and the effect of regeneration step on the SCR catalyst



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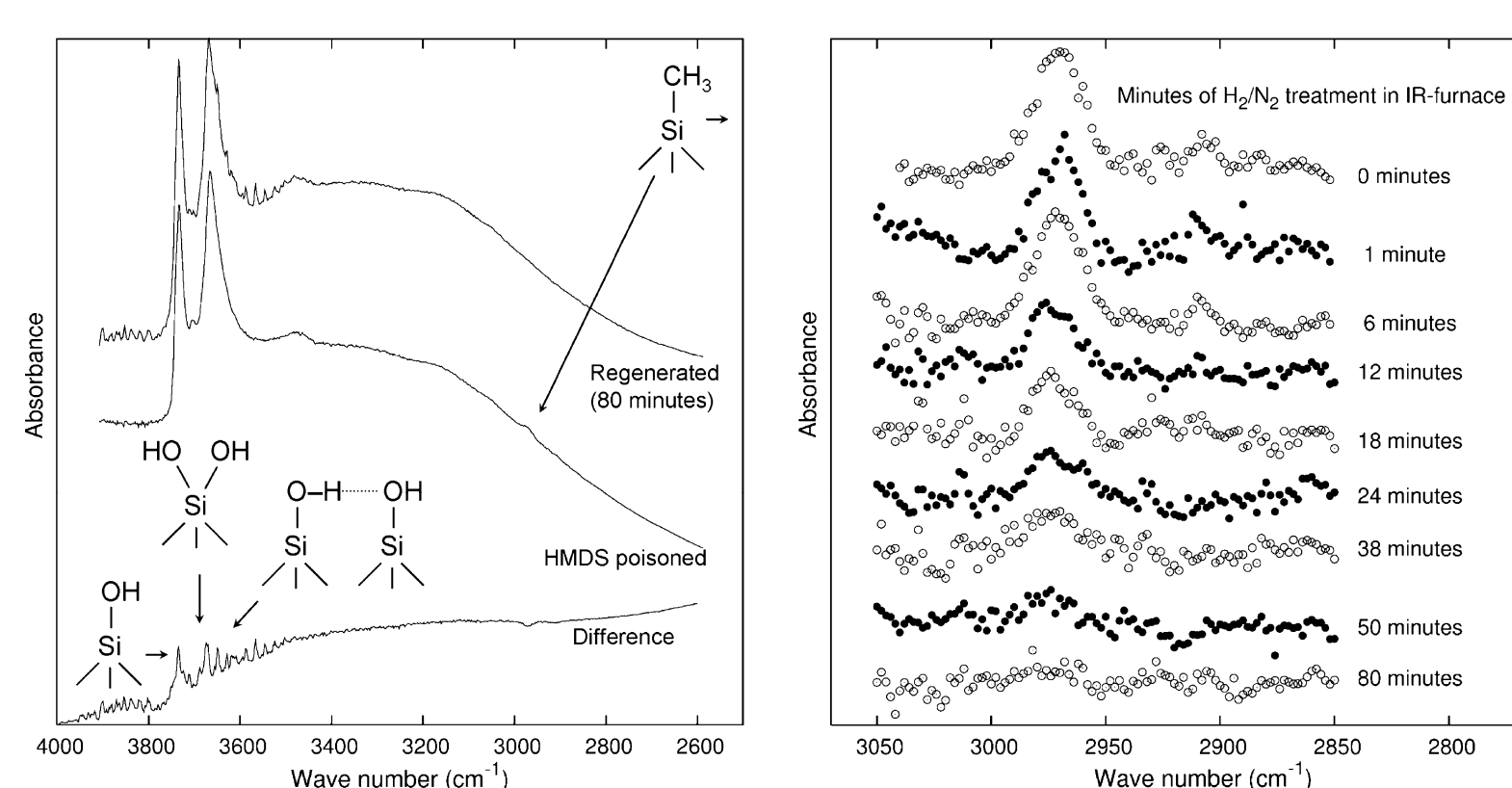
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## 1. Introduction

MUNICIPAL waste flue gas was previously<sup>[1]</sup> found to deactivate the Pt-based CO oxidation catalyst severely. In the specific case studied, siloxanes were found to cause the deactivation. An on-site method for complete regeneration of the catalyst activity was found without shutdown of the flue gas stream, i.e. by *in situ* treatment of the Pt-catalyst by reductive H<sub>2</sub>-gas, outlined in Fig. 1.



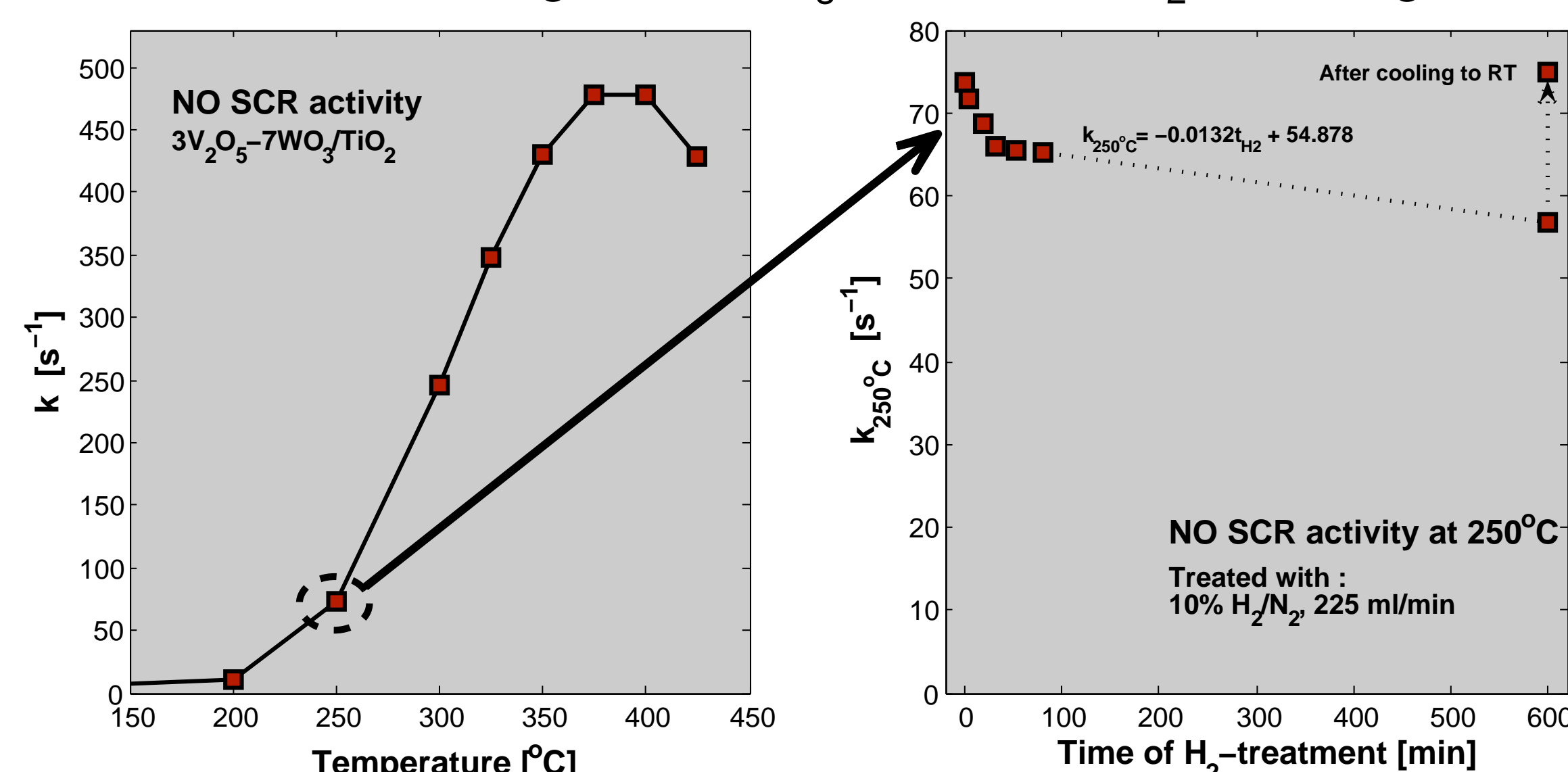
**Figure 1:** (Right) High temperature-FTIR (250°C) spectra of hexamethyldisiloxane-poisoned Pt/TiO<sub>2</sub> catalyst. (Left) Poisoned catalyst before and after treatment with 10% H<sub>2</sub>/N<sub>2</sub><sup>[1]</sup>

However, introduction of H<sub>2</sub> gas in the gas stream could also affect other units in the tail pipe gas cleaning system. Of special interest here, is the effect of hydrogen gas on the performance of the DeNO<sub>x</sub> + SCR catalytic process, i.e. the reaction  $4\text{NO} + 4\text{NH}_3 + \text{O}_2 \xrightarrow{\text{V}_2\text{O}_5-\text{WO}_3/\text{TiO}_2} 4\text{N}_2 + 6\text{H}_2\text{O}$ .

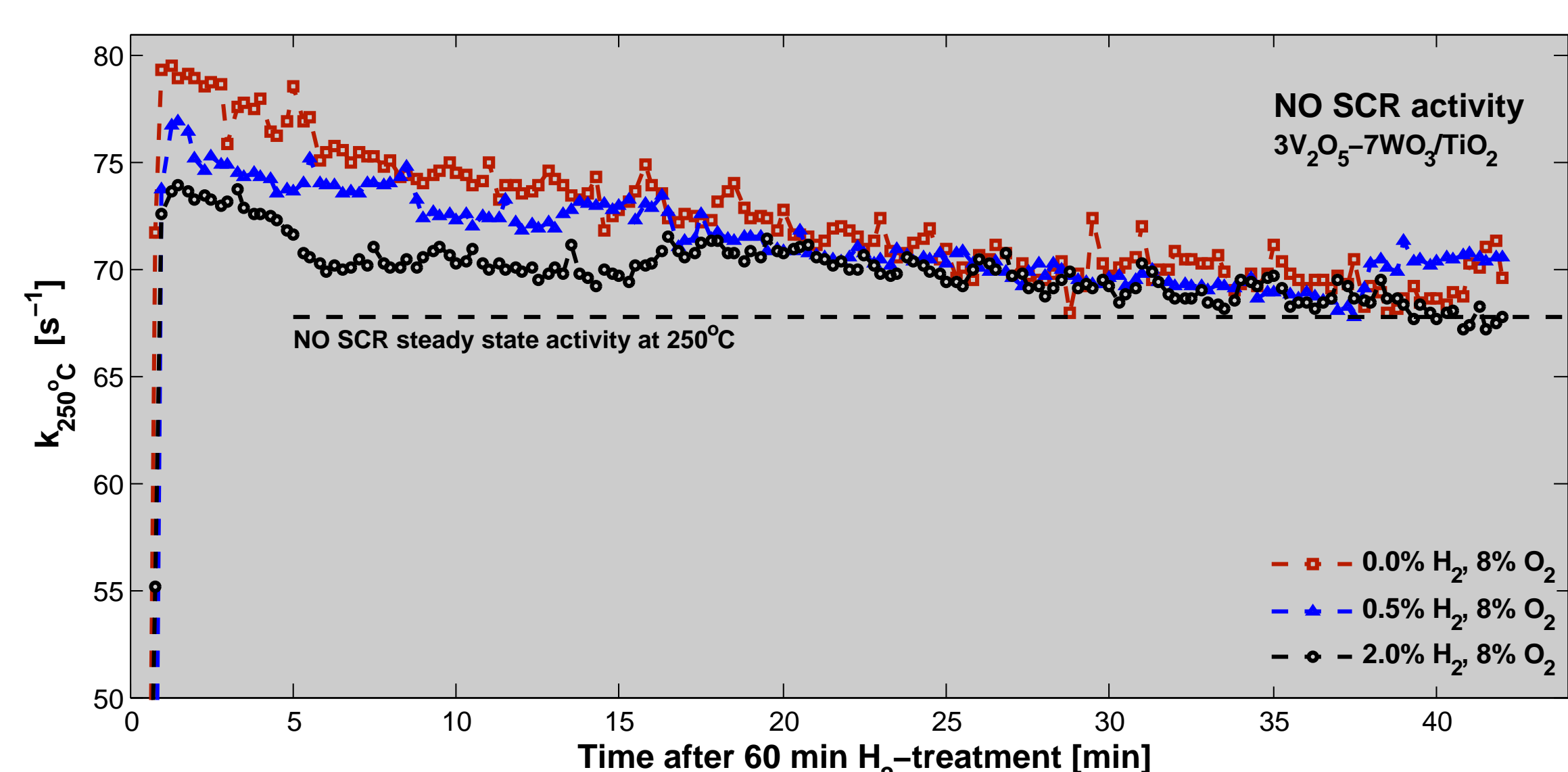
## 2. NO SCR Activity

THE impact of hydrogen on the catalytic activity of the 3%V<sub>2</sub>O<sub>5</sub>-7%WO<sub>3</sub>/TiO<sub>2</sub> catalyst at 250°C was investigated in two steps.

Exposure of the SCR catalyst to 10% H<sub>2</sub>/N<sub>2</sub> reveals a dual-influence on the activity (Fig. 2, right): Up until ≈30 min in H<sub>2</sub> atmosphere, only the surface vanadate groups (V<sup>5+</sup> and V<sup>4+</sup>) are reduced to V<sup>3+</sup>, decreasing the catalytic performance. At longer times of exposure, the slope has decreased, indicating that WO<sub>3</sub> or bulk TiO<sub>2</sub> is being reduced.



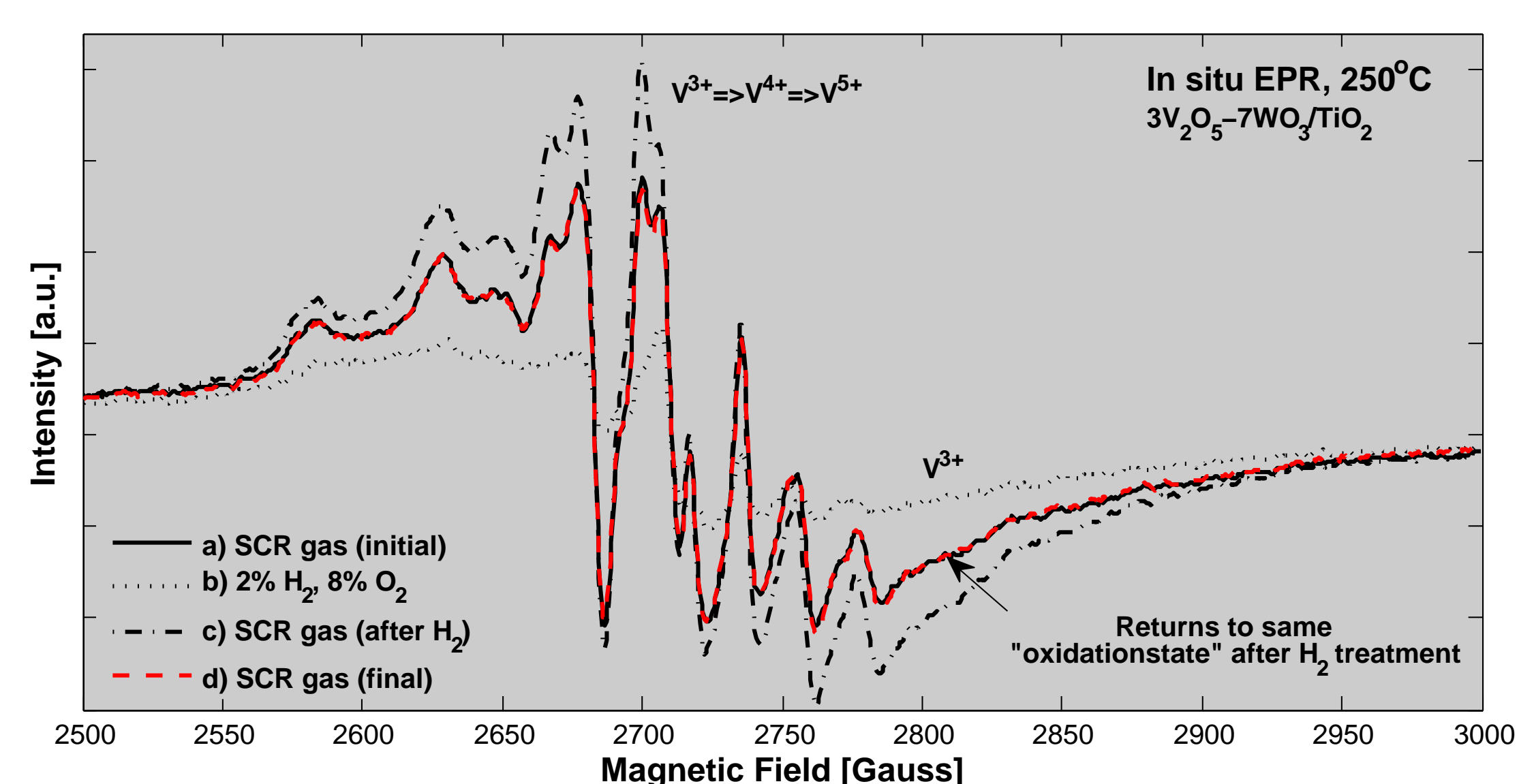
**Figure 2:** NO SCR activity vs. temperature for the standard SCR-catalyst, 3V<sub>2</sub>O<sub>5</sub>-7WO<sub>3</sub>/TiO<sub>2</sub> (left). NO SCR activity at 250°C of the catalyst vs. time of preliminary 10% H<sub>2</sub>/N<sub>2</sub> exposure of the catalyst (right)



**Figure 3:** Time of regeneration in SCR gas of 3V<sub>2</sub>O<sub>5</sub>-7WO<sub>3</sub>/TiO<sub>2</sub> at 250°C after 60 min exposure to different H<sub>2</sub>-conc. in 8% O<sub>2</sub>. Notice that initial steady-state activity is regained within about 30 min at these conditions

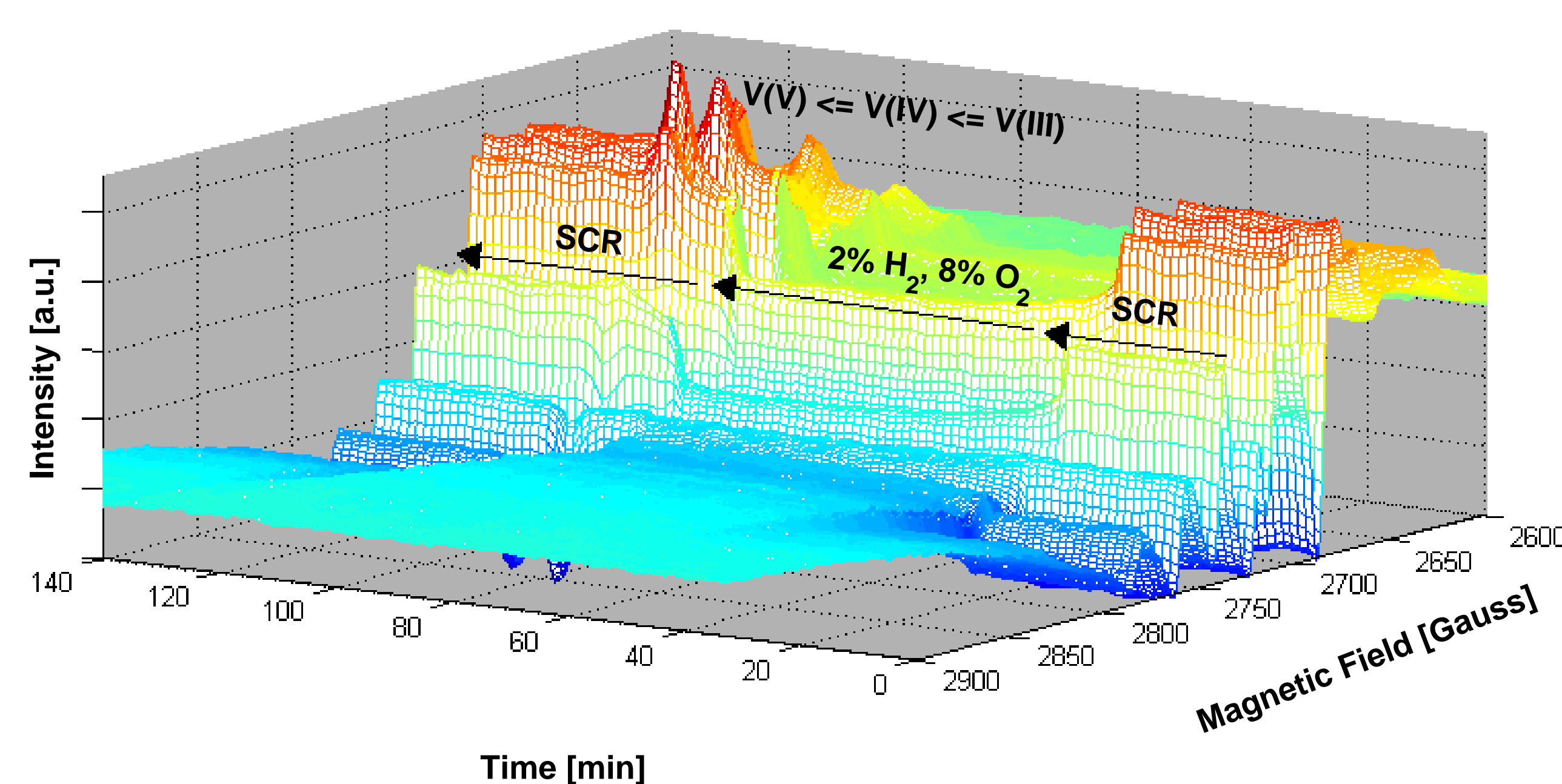
## 3. EPR spectroscopy

FROM the spectra it is evident that vanadium in the catalyst is reduced upon exposure to the hydrogen/oxygen mixture, observed as a reduction in signal from the V<sup>4+</sup> species – the only EPR active vanadium species. It is possible that both the V<sup>5+</sup> and V<sup>4+</sup> species are reduced to V<sup>3+</sup>.



**Figure 4:** In situ EPR at 250°C at four key-points, a) start of NO SCR gas treatment, b) 2% H<sub>2</sub>, 8% O<sub>2</sub> gas at steady state, c) immediately after switch back to SCR gas, detected increase in concentration of V<sup>4+</sup>, due to formation of V<sup>4+</sup> and V<sup>5+</sup> from V<sup>3+</sup>, d) steady state SCR conditions, notice that the system is completely reversible

The observed variation in the continuous spectrum (Fig. 5) is due to the oxidation of V(III) firstly to V(IV) and then to V(V): V<sup>3+</sup> = V<sup>4+</sup> = V<sup>5+</sup>, creating the maximum in the spectra vs. time.



**Figure 5:** EPR spectra of V<sup>4+</sup> in NO SCR gas, shift to 2% H<sub>2</sub>, 8% O<sub>2</sub> for 60 min and shift back to SCR conditions

However, the 'excess' of the formed V(IV) is only intermediate, and the system quickly returns to the same distribution of vanadium oxidation states as before the hydrogen treatment.

## 4. Conclusion

TRADITIONAL titania-based SCR catalysts is practically not influenced by temporarily exposure to reductive gases. Thus, no permanent deactivation of the industrial SCR catalyst would be expected by exposure of such catalysts to diluted hydrogen/oxygen gas.

## References

- [1] Rasmussen, S.B., Kustov, A.L., Due-Hansen, J., Siret, B., Tabaries, F., Fehrmann, R., *Appl. Catal. B*, 69 (2006) 10–16